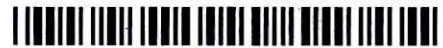




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3319-1
Job Sheet 179541



Part No: D3319-1

Job Qty: 12 ea

Part Name: Forward Wearplate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/3/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: IPP: B 05.10.14 Added step 9, dwg rev B KJ/EC IPP Rev:C Now on Waterjet 06-10-26 JLM IPP REV:D
17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	7/3/18	7/3/18	0.00	0.00	Start Up Waterjet		SC 18/06/18
100	Waterjet	12 pcs	7/3/18	7/3/18	0.00	1.25	Waterjet1		SC 18/06/18
110	QC	12 pcs	7/3/18	7/3/18	0.00	0.00	QC2 Waterjet-2		SC 18/06/18
120	QC	12 pcs	7/3/18	7/3/18	0.00	0.00	QC8-2		SC 18/06/18
140	Brake NC	12 pcs	7/3/18	7/3/18	0.07	0.87	Brake NC 1		SC 18/06/18
150	QC	12 pcs	7/3/18	7/3/18	0.00	0.00	QC5		SC 18/06/18
160	Autoweld 1	12 pcs	7/3/18	7/3/18	0.00	3.08	Automated welding		SC 18/06/18
170	QC	12 pcs	7/3/18	7/3/18	0.00	0.00	QC10		SC 18/06/18
180	QC	12 pcs	7/3/18	7/3/18	0.00	0.00	QC5		SC 18/06/18
190	SprayPaint	12 pcs	7/3/18	7/3/18	0.00	0.28	Spray Paint		SC 18/06/18
200	QC	12 pcs	7/3/18	7/3/18	0.00	0.00	QC3		SC 18/06/18
210	Packaging	12 pcs	7/3/18	7/3/18	0.00	0.00	Packaging3-1		SC 18/06/18
220	QC21-SA	12 Ea	7/3/18	7/3/18	0.00	0.00	QC21		SC 18/06/18

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary
Descriptions: 140 - 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: 2 Form flat on press using DT8776 block
160 - 8259 HARDCOAT B:
190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.
BATCH: 13888
210 - Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd.
P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	7.5360 sf (.628 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S18GA	8	194	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation

--

Completed By _____
 ID / Supervisor _____
 al Verification _____
 Coordinator _____
 Approval _____

DART AEROSPACE
 1270 Aberdeen Street
 New Bedford, MA 01944
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Part: D3319-1
 Job No: 179541
 Serial No/Batch: S082830
 Container No: S082830
 Date: 06/20/18

Root Cause			
Environment ☐	No Re-verification ☐	Pressure/Fo ☐	Red Wrong ☐
Design ☐	Operator ☐	Bending ☐	Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not C ☐	nder tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	orrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/i ☐	st/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	4.980inches $\pm$ 0.030	5.010 4.950		
2	Wearplate	1.600inches $\pm$ 0.010	1.610 1.590		
3	Wearplate	2.660inches $\pm$ 0.010	2.670 2.650		
4	Wearplate	3.190inches $\pm$ 0.010	3.200 3.180		
5	Wearplate	3.563inches $\pm$ 0.010	3.573 3.553		
6	Wearplate	4.710inches $\pm$ 0.030	4.740 4.680		
7	Wearplate	0.600inches $\pm$ 0.030	0.630 0.570		
8	Wearplate	10.576inches $\pm$ 0.010	10.586 10.566		
9	Wearplate	11.942inches $\pm$ 0.010	11.952 11.932		
10	Wearplate	18.090inches $\pm$ 0.030	18.120 18.060		
11	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315		
12	Wearplate	0.546inches $\pm$ 0.010	0.556 0.536		
13	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315		
14	Wearplate	0.670inches $\pm$ 0.010	0.680 0.660		
15	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189		
16	Wearplate	3.815inches $\pm$ 0.010	3.825 3.805		
17	Wearplate	16.100inches $\pm$ 0.010	16.110 16.090		

Plex 6/20/18 8:58 AM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	